

Date: Friday, 01/02/2008 8:56:53 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOOR DOUBLER
 Job Number : 37135
 Estimate Number : 13149
 P.O. Number :
 This Issue : 01/02/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : SMALL /MED FAB
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 08-01-30 new issue DD verified by:

Part Number : D37011
 Drawing Number : D3701 *U/R prototype*
 Project Number : N/A
 Drawing Revision : U/R
 Material :
 Due Date : 08/02/2008 Qty: 2 Um: Each

Additional Product

PROTOTYPE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 1.0545 sf(s)/Unit Total: 2.1090 sf(s)
 6061T6 aluminium sheet .080" thick
 (M6061T6S080)
 Batch: *106320 IB 8-2-1*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3701
 Dwg Rev: *U/R*
 Prog Rev: *U/R*

IB 8-2-1

(2)

2- Deburr if necessary

IB 8-2-1

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-2-1

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr if necessary

2- form as per dwg D3701

IB 08-02-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/02/2008 8:56:53 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR DOUBLER

Job Number: 37135

Part Number: D37011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Bob 08-07-20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

N/A

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

D 21 Stas

Bob 08-07-20

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Doel 05/20

Job Completion



MF 08-05-16

FOR ENGINEERING USE ONLY

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.



Product #: D412-761

Job #: 00224A

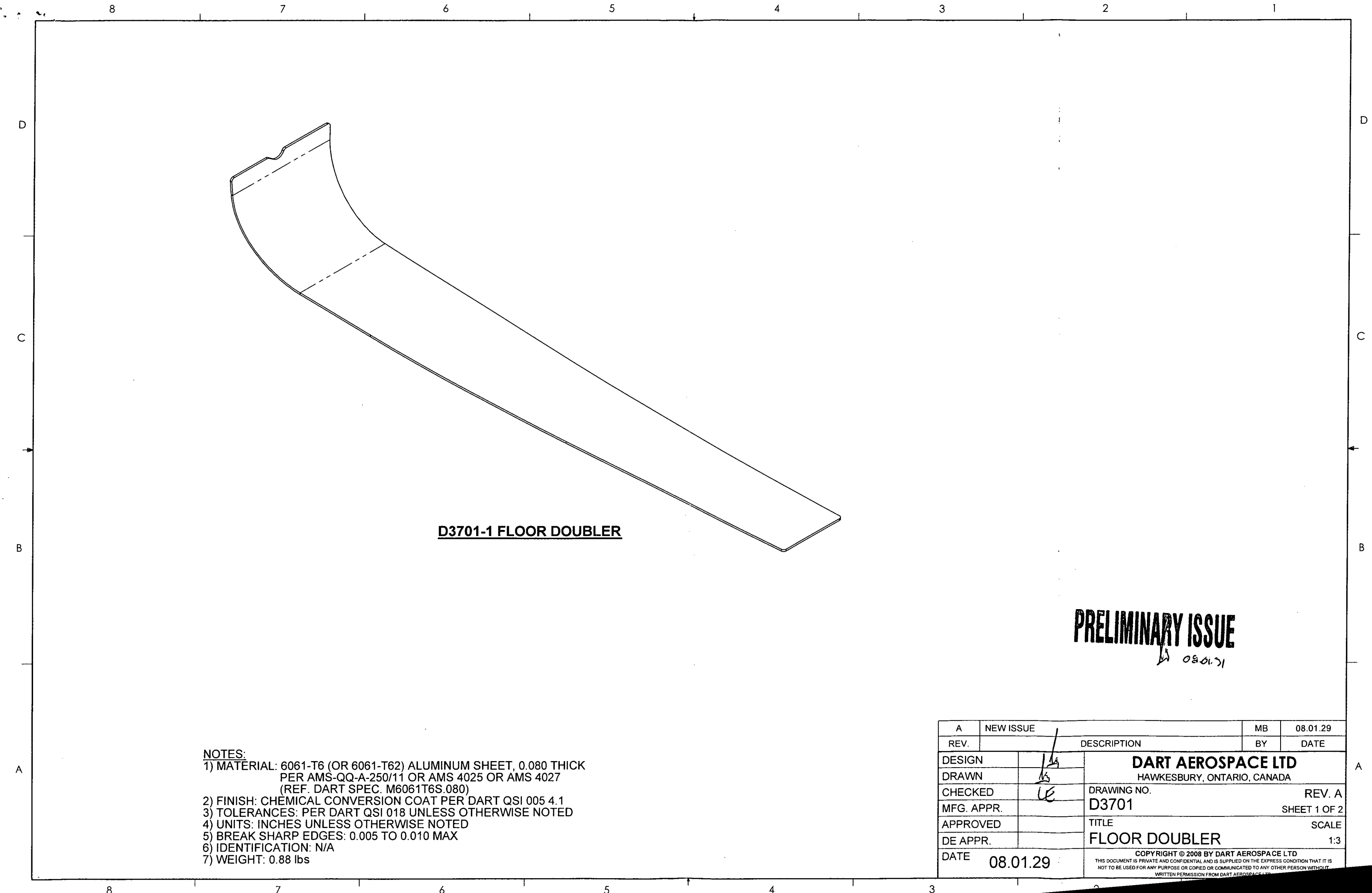
Date: 08.01.31

Product Name: VERTICAL REFERENCE DOOR

Requested By: MB

Design Manager Approval: [Signature]

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
2	D3700-1	INBOARD WINDOW DOUBLER	08.01.29	YES	ASAP	SEE BELOW	
2	D3700-3	OUTBOARD WINDOW DOUBLER	08.01.29	YES	ASAP	SEE BELOW	
2	D3701-1F	(FLOOR DOUBLER) FLAT PATTERN	08.01.29	YES	ASAP	SEE BELOW	
2	D3702-1	FORWARD DOUBLER	08.01.30	YES	ASAP	MAKE ONE WITH HOLES/SLOT + ONE WITHOUT HOLES/SLOT + SEE BELOW.	
2	D3703-1	AFT DOUBLER	08.01.30	YES	ASAP	SEE BELOW	
						HAND ALL W/Os AND PARTS TO DAN STOW	



D3701-1 FLOOR DOUBLER

PRELIMINARY ISSUE
08.01.29

- NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.88 lbs

A	NEW ISSUE	MB	08.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3701	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FLOOR DOUBLER	1:3
DATE	08.01.29	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

